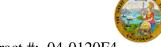
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: <u>SF/ALA</u> Rte: <u>80</u> PM: <u>13.2/13.9</u>

File #: 69.12

DAILY PROJECT JOURNAL

Prime Contractor: American Bridge/Fluor Enterprises, a JV Report No: DPJ-000347 **Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island Dated: 12-Oct-2007

Location: Changxing Island, Shanghai, China

Submittals(New / Total): CWR's: 0		HSR's: 0/6	NCR's: 0 / 10	
Title	Detail			
Major component movement 77m Tower Mock-up:				
	ZPMC Heat	Straightening Skin Plate E.		
	89m Tower	Mock-up:		
	Welding Ski	n Plate butt joints.		
	114m Tower	Mock-up:		
	Bending dia	phragm flange plates.		
	Closed-rib V	Veld Trials:		
	QA began di	mensional verification of Close	ed-rib joint geometry, however	
	verification	was suspended after ABF infor	med QA the ribs being verified	
	did not meet	rib bend geometry requiremen	ts. ZPMC will prepare 5 other	
	ribs this wee	kend and QA verification will	begin Monday, October 15, 2007.	
Meetings attended	QA met with	QA met with ABF and ZPMC at 1400 to discuss the schedule for the next		
	two days:			
	Moody Inter	national will perform side bend	l testing of welder qualification	
	test plates at	9am Monday, October 15, 200	7.	
	Verification	of joint geometry for the Close	d-rib Weld Trials is scheduled	
	for Monday,	October 15, 2007.		
	77m Tower	Mock-up:		
	Skin A awai	ting CWR for 3rd time repair,		
	MT Connect	ion Plates on Skin Plate D,		
	Heat Straigh	ten Skin Plate E,		
	Begin Weldi	ng Diaphragm flange plate but	t joints pending 2 additional	
	flange plate	from Wuxi Boiler.		
	89m Tower	Mock-up:		
	Weld Skin P	late Butt Joints,		
	Beveling Sk	in Plates.		
	Title Major component movement	Title Major component movement 77m Tower of ZPMC Heat 89m Tower of Welding Ski 114m Tower Bending diap Closed-rib Word QA began diverification of did not meet ribs this wee Meetings attended QA met with two days: Moody Intertest plates at Verification for Monday, 77m Tower of Skin A await MT Connect Heat Straigh Begin Welding Flange plate and Skin Power of Weld Skin Power of Skin A wait weld skin Power of Skin A wait weld skin Power of Skin A well and skin Power of Skin A wait weld skin Power of Skin A well skin Power of Skin A well skin Power of Weld Skin Power of Weld Skin Power of Skin A well skin Power of Weld Skin Power of Weld Skin Power of Weld Skin Power of Weld Skin Power of Skin A wait weld skin Power of We	Title Major component movement 77m Tower Mock-up: ZPMC Heat Straightening Skin Plate E. 89m Tower Mock-up: Welding Skin Plate butt joints. 114m Tower Mock-up: Bending diaphragm flange plates. Closed-rib Weld Trials: QA began dimensional verification of Close verification was suspended after ABF infordid not meet rib bend geometry requirement ribs this weekend and QA verification will Meetings attended QA met with ABF and ZPMC at 1400 to display to the component of the co	

DAILY PROJECT JOURNAL (Continued Page 2 of 3)

		114m Tower Mock-up:	
		Work pending resolution of stiffener to skin plate repair rate.	
3	Key conversations	Caltrans met with ABF and ZPMC at 1300 to discuss issues related to	
		fabrication:	
		77m Tower Mock-up Diaphragm (type 3) Flange (60mm):	
		ZPMC verified the template from Wuxi Boiler matches the cutouts in the	
		diaphragm. ZPMC thinks the flanges relaxed during shipment which	
		accounts for the difference in gap measurements take at Wuxi Boiler from	
		those taken at ZPMC on the actual diaphragm. ZPMC will grind contact	
		points on the diaphragm to facilitate fitting.	
		89m Tower Mock-up Diaphragm (type 2) Flange (20mm):	
		ZPMC may request heat straightening on one flange, ZPMC to re-fabricate	
		some other flanges tonight.	
		Materials Issues:	
		ABF/ZPMC will submit Material Test Reports (MTR's) with associated	
		grain size reports from the mill. Caltrans requested upcoming check	
		samples to include some plates with these supplemental tests to allow	
		verification of grain size. Caltrans also requested an estimated time of when	
		all of the plates requiring these supplemental tests will be identified and a	
		quantity of material. Future mill orders shall include grain size on the	
		MTR's.	
		ABF will verify the weldability of the channel and angle for the mock-up	
		that does not meet the Q235 specification.	
		Intersecting Weld Demonstration:	
		ABF asked if the 18mm plate should be spliced as detailed or cut in one	
		piece. Caltrans responded that the demonstration should simulate actual	
		production.	
4	Other important observations	ABF and ZPMC asked QA to observe their current closed-rib UT procedure	
		development. The procedure demonstrated was conducted in the 3rd leg of	
		sound and utilized the sound path distance to calculate the depth of	
		penetration. This contradicts previous information about the line of	
		development ABF had been informing QA about. QA demonstrated the	
		calibration of the amplitude based procedure to ABF and ZPMC Level III's.	
		ABF Level III Steve Lawton appeared to be receptive to such a procedure	
		due to its speed, ease of use and demonstrated accuracy on other projects.	
		ZPMC Level III Steven Kang was not receptive to the technique, citing	
		possible issues with variations in surface profile and pressure on the probe.	
		Mr. Kang stated the distance based procedure was accurate and he plans to	
		begin identifying LOP on welded closed-rib samples for destructive testing	
		to determine the procedures accuracy.	
5	Quality Assurance Inspectors per shift		
		3 Swing Shift (Berger, Dixon, Smith)	
		5 5 ming billit (Berger, Bilton, billitin)	

DAILY PROJECT JOURNAL

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ZPMC informed Caltrans that the night shift will be stopped and will not 6 Logistics resume until the issues with weld quality on the skin plate to stiffener plate CJP welds is resolved and production of this type of joint resumes.

Inspected By: McClary, David **Quality Assurance Inspector Reviewed By: QA** Reviewer Lowry, Patrick